

Date: Tuesday, 1/3/2006 4:18:27 PM
User: Kim Johnston

SPLIT

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: BEARPAW KIT (19"X24")	
Job Number	: 25367 A					
Estimate Number	: 10323					
P.O. Number	: N/A			Part Number	: K10008	
This Issue	: 1/3/2006	S.O. No.	: N/A	Drawing Number	: D2432 REV F3	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A			Drawing Revision	: F3	
Previous Run	: 24965			Material	: N/A	
Written By	<u>SEE COMMENT BELOW</u>			Due Date	: 1/30/2006	
Checked & Approved By	<u>SEE COMMENT BELOW</u>			Qty:		
Comment	: Est Rev:J 04.02.17 Blank size changed KJ/JLM					
Additional Product						
Job Number:						
Seq. #:	Machine Or Operation:		Description :			
1.0	DC		DOCUMENT CONTROL 			
<p>Comment: DOCUMENT CONTROL Photocopy bluefile: K10008 D206-559-013 D350-578-011 D315-670-011 D427-659-011 and create labels per PPP K10008 CHG006(Bag Bluefiles separately)</p> <p style="text-align: right;">DIT. 06/01/19</p>						
2.0	MUHMWB10		UHMW 1" Black 			
<p>Comment: Qty.: 6.8250 sf(s)/Unit Total: 136.5000 sf(s) blank: 19.500" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5 Material: Black UHMW 1" (MUHMWB10) Batch: m19541</p> <p style="text-align: right;">JL/SD 06.01.19</p>						
3.0	HAAS1		HAAS CNC VERTICAL MACHINING #1 			
<p>Comment: HAAS CNC VERTICAL MACHINING #1 Note:(2) bearpaws for (1) Kit</p> <p>1-Inspect material for defects or damage prior to machining</p> <p>2-Machine as per Folio and Dwg D2432 Identify as D2432F</p> <p>3-Deburr</p> <p style="text-align: right;">JL / SD 06.01.19</p>						

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:	Machine Or Operation:	Description :
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	JL/SN 06.01.19
5.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	E 06/01/23
6.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1	
	Pick Packing Kit	
7.0	D2182B	Neoprene Cushion-.750 bl
	Comment: Qty.: 0.4160 f(s)/Unit Total : 8.3200 f(s)	
	Pick: Packing Kit	
	Qty Part Number Description Batch	
	6 D2182B050 Rubber Cushion	B23172
8.0	D2274	Radius Block
	Comment: Qty.: 12.0000 Each(s)/Unit Total : 240.0000 Each(s)	
	Pick: Packing Kit	
	Qty Part Number Description Batch	
	12 D2274 Radius Block	B24872
	2 D2432F(ref only) Bearpaw	B 25367
9.0	D2438	Clamp
	Comment: Qty.: 6.0000 Each(s)/Unit Total : 120.0000 Each(s)	
	Pick: Packing Kit	
	Qty Part Number Description Batch	
	6 D2438 Clamp	B23818

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:	Machine Or Operation:	Description :	
10.0	D2529	Washer	
<p>Comment: Qty.: 12.0000 Each(s)/Unit Total : 240.0000 Each(s) Pick: Packing Kit Qty Part Number Description Batch 12 D2529 Washer <u>B23177X129/B25372X15</u></p>			
<p>Comment: Qty.: 0.4160 Each(s)/Unit Total : 8.3200 Each(s) Pick: Packing Kit Qty Part Number Description Batch 6 D2732-050 Rubber Cushion <u>B24182</u></p>			
12.0	AN415A	Bolt	
<p>Comment: Qty.: 12.0000 Each(s)/Unit Total : 240.0000 Each(s) Pick: Packing Kit Qty Part Number Description Batch 12 AN4-15A Bolt <u>M19085</u></p>			
13.0	AN417A	Bolt	
<p>Comment: Qty.: 12.0000 Each(s)/Unit Total : 240.0000 Each(s) Pick: Packing Kit Qty Part Number Description Batch 12 AN4-17A Bolt <u>M15432</u></p>			
14.0	AN960JD416	Washer	
<p>Comment: Qty.: 24.0000 Each(s)/Unit Total : 480.0000 Each(s) Pick: Packing Kit Qty Part Number Description Batch 24 AN960JD416 Washer <u>M18431</u></p>			

W/O:		WORK ORDER CHANGES						
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Job Number:



Seq. #: Machine Or Operation:

Description :

15.0 MS21042L4 Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total: 240.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4 Nut (or -4) M17997

C Log 101123 (12)

16.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

17.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPK10008

Location: NEVR

Log 101123 (12)

18.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

545 06/01/23 (12)

(12) 06/01/23 (12)

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/01/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	25367
Description: Bearpaw	Part Number:	D2432
Inspection Dwg: D2432	Rev: F3	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:	<u>SD</u>	Audited by:	<u>SG</u>	Prototype Approval:	N/A
Date:	<u>06-01-19</u>	Date:	<u>06-01-19</u>	Date:	<u>N/A</u>

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	KJ/RF	





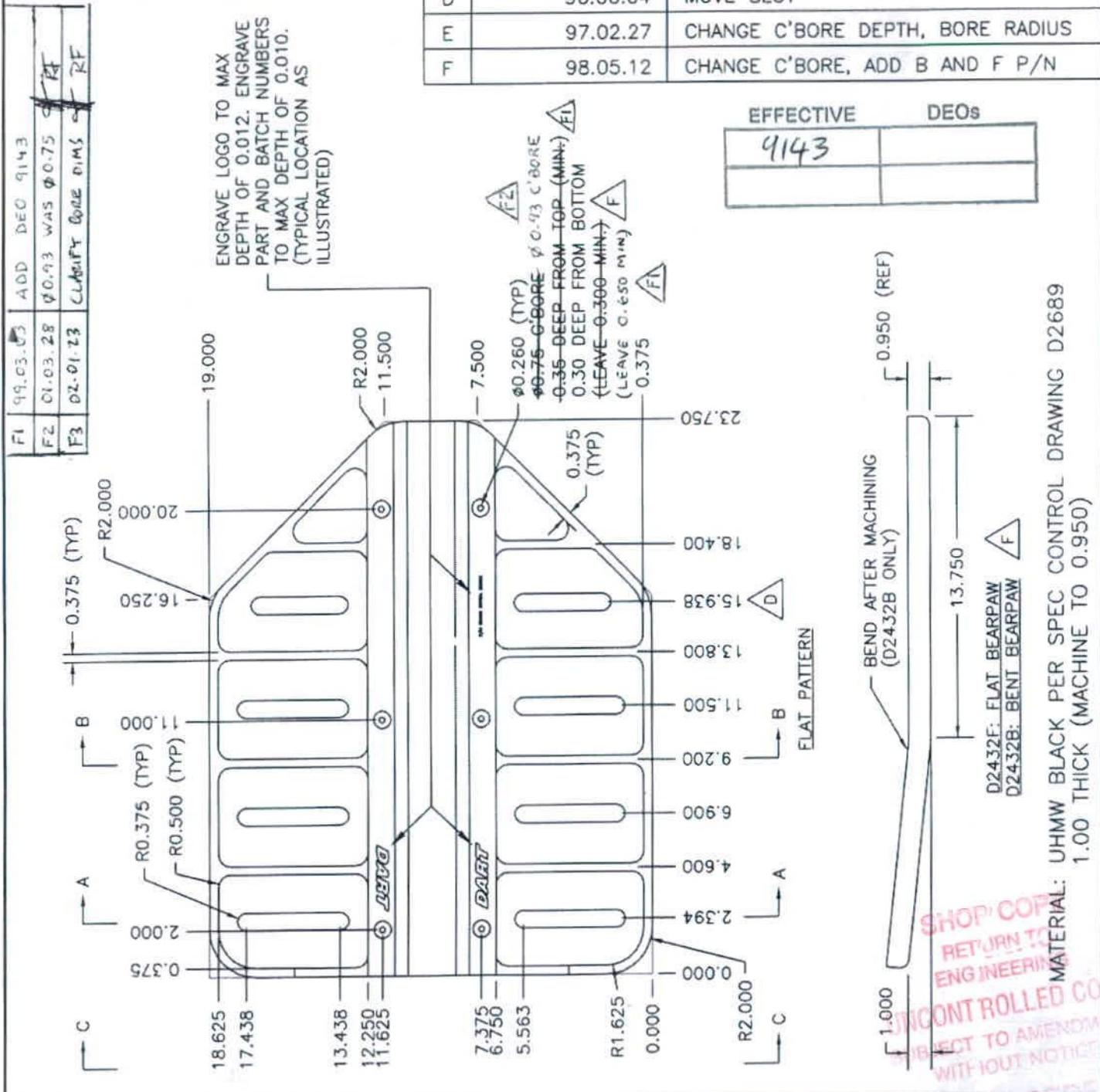
RELEASED
98.06.17 KE

98.06.17 KG

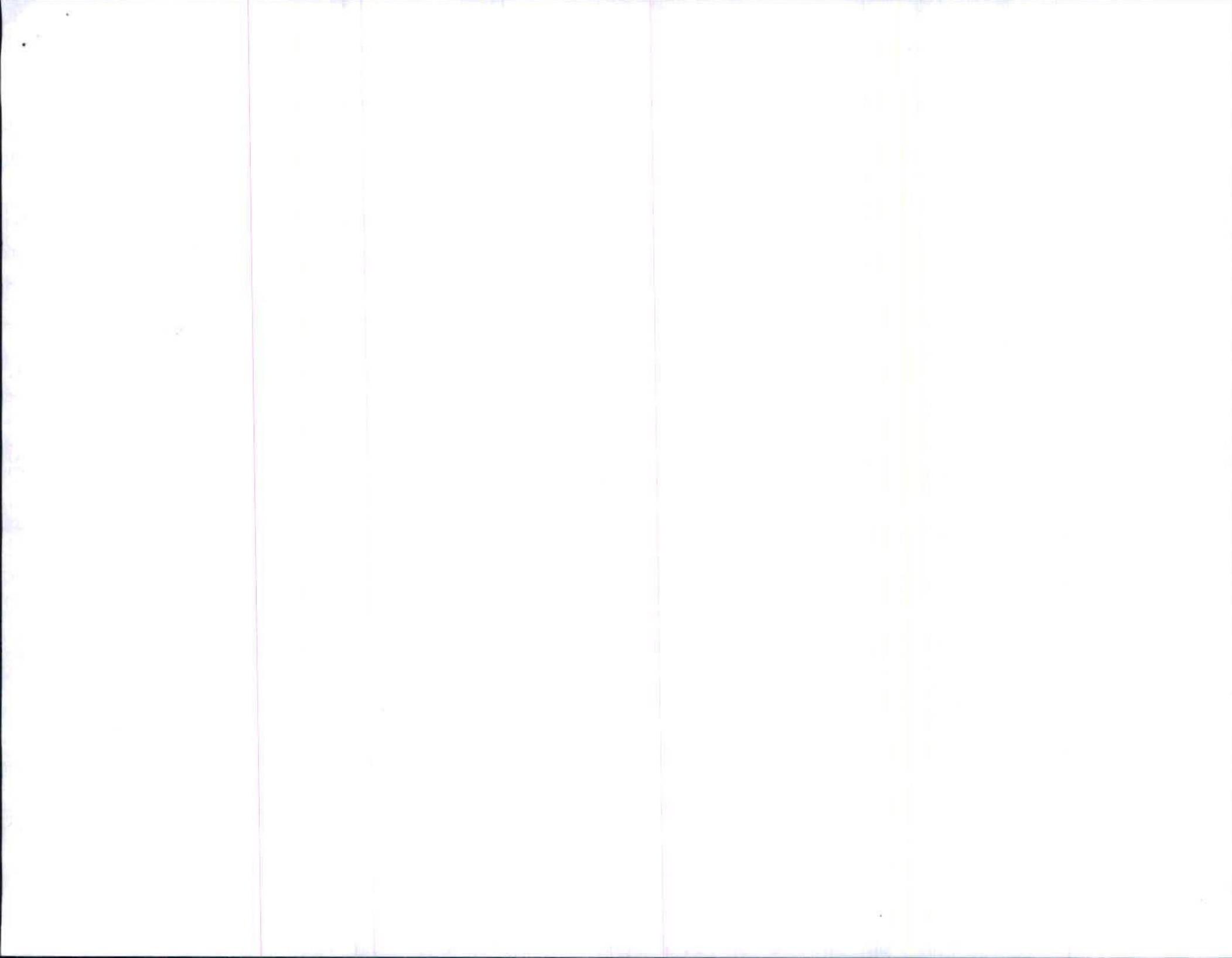


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MJ</i>	APPROVED <i>SJ</i>	DRAWING NO. D2432	REV. F SHEET 1 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:6
A	95.10.31	NEW ISSUE	
B	96.01.24	RE-DESIGN	
C	96.03.26	CHANGE BORE AND C'BORE DEPTH	
D	96.06.04	MOVE SLOT	
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS	
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N	

ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)

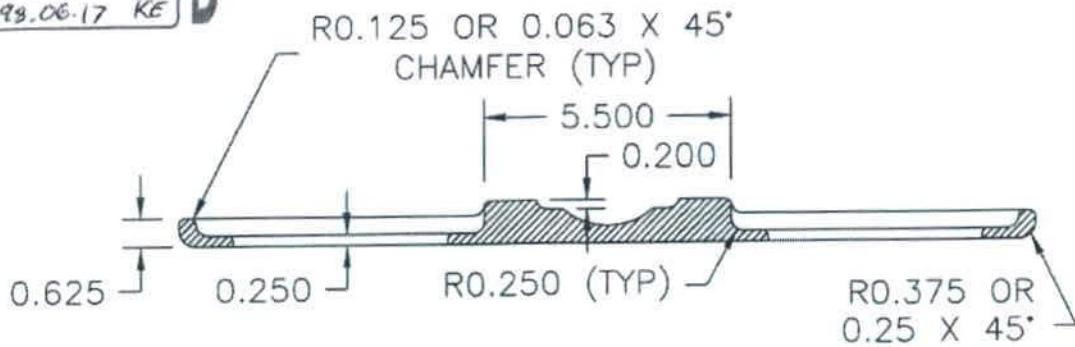
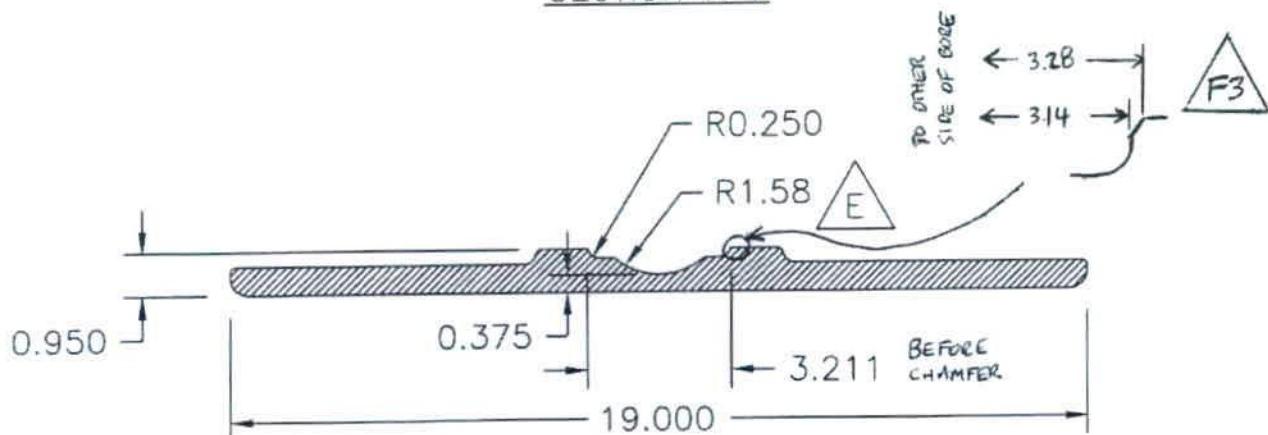
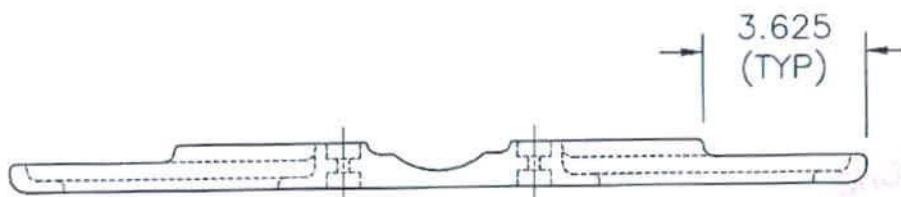


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DART

DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MW</i>	APPROVED <i>CS</i>	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:4

RELEASED
98.06.17 KESECTION A-ASECTION B-BSECTION C-C

